# DART SERVICE INSTRUCTION

## TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3 OR EARLIER

REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

### 1.0 PURPOSE

The DSI 9670-011 Step Modification Kit has been made available for operators who would like to lower a D350-591-121/-122 High Skid Step Assembly to improve compatibility with a D350-607-XXX Basket installation.

The DSI 9670-013 Step Modification Kit has been made available for operators who would like to lower a D350-591-213/-214/-311/-312 High Skid Step Assembly to improve compatibility with a D350-607-XXX Basket installation.

### 2.0 INSTALLATION

**2.1 FOR D350-591-121/-122 High Skid Step Assembly**

**2.1.1** Remove the Step Assembly from the aircraft. Retain all fasteners.

**2.1.2** Remove qty (16) rivets fastening Step Leg Assembly D2582 to the D2351-041/-042 Step Assembly. See Figure 1. Drill a ∅ 0.25" hole in the bottom of the step 0.25" from the forward end. Hold the step vertically with the hole end down. Inject Sikaflex/Proseal into the hole to 'capture' any rivet stems inside the step and cover the drilled hole. Allow to cure before proceeding.

**2.1.3** Install Mid Step Leg Assembly D4964-041 using qty (16) NASM20600AD4W4 rivets, (8 per side). See Figure 2.

**2.1.4** Touch up paint finish as required with chemical film material (Alodine 1200 or 1201) per MIL-C-5541, one coat of MIL-P-85582 or MIL-P-23377 primer, and 2-3 coats of MIL-C-85285 polyurethane coating to match original finish. Clean off any flaking anti-skid and touch up with Black Anti-Skid paint per MIL-W-5044 Type 2.

**2.1.5** Re-install the Step Assembly on to the aircraft per ICA-D350-591.

**2.2 FOR D350-591-213/-214/-311/-312 High Skid Step Assembly**

**2.2.1** Remove the Step Assembly from the aircraft. Retain all fasteners.

**2.2.2** Remove qty (16) rivets fastening Step Leg Assembly D3065-041 and Spacer D3066-1 (2 PL) to D3078-041/-042 Step Assy or D3272-041/-042 Step Assy. Retain Spacer D3066-1 (2). See Figure 1. Drill a ∅ 0.25" hole in the bottom of the step 0.25" from the forward end. Hold the step vertically with the hole end down. Inject Sikaflex/Proseal into the hole to 'capture' any rivet stems inside the step and cover the drilled hole. Allow to cure before proceeding

**2.2.3** Install Mid Step Leg Assembly D4964-043 and Spacer D3066-1 using qty (16) NASM20600AD4W4 rivets, (8 per side). See Figure 3.

**2.2.4** Touch up paint finish as required with chemical film material (Alodine 1200 or 1201) per MIL-C-5541, one coat of MIL-P-85582 or MIL-P-23377 primer, and 2-3 coats of MIL-C-85285 polyurethane coating to match original finish. Clean off any flaking anti-skid and touch up with Black Anti-Skid paint per MIL-W-5044 Type 2.

**2.2.5** Re-install the Step Assembly on to the aircraft per ICA-D350-591.

### 3.0 WEIGHT AND BALANCE

There is negligible weight change with this modification.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: _____
D. SHEPHERD (DE # 02)

DATE: 13.10.30
CERT. NO.: SH92-6
ISSUE NO.: 11

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| A | NEW ISSUE | DB | 13.10.30 |

| | | | |
|---|---|---|---|
| DESIGN | DB | DART AEROSPACE LTD | |
| DRAWN | DB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9670 | SHEET 1 OF 3 |
| APPROVED | | TITLE HIGH SKID MID STEP MODIFICATION KIT | SCALE NTS |
| DE APPR. | | | |
| DATE | 13.10.30 | | |

## 4.0 PARTS LIST

**FOR D350-591-121/-122 High Skid Step Assembly (FIGURE 2)**

| ITEM | QTY -011 | P/N | DESCRIPTION |
|---|---|---|---|
| | X | **DSI 9670-011** | **STEP MODIFICATION KIT** |
| | | | |
| 1 | 1 | D4964-041 | MID STEP LEG ASSY |
| 2 | 16 | NASM20600AD4W4 | RIVET |

**FOR D350-591-213/-214/-311/-312 High Skid Step Assembly (FIGURE 3)**

| ITEM | QTY -013 | P/N | DESCRIPTION |
|---|---|---|---|
| | X | **DSI 9670-013** | **STEP MODIFICATION KIT** |
| | | | |
| 1 | 1 | D4964-043 | MID STEP LEG ASSY |
| 2 | 16 | NASM20600AD4W4 | RIVET |

| | | | |
|---|---|---|---|
| DESIGN | DB | **DART AEROSPACE LTD** | |
| DRAWN | DB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | [illegible] | DRAWING NO. DSI 9670 | REV. A |
| MFG. APPR. | N/A | | SHEET 2 OF 3 |
| APPROVED | [illegible] | TITLE HIGH SKID MID STEP MODIFICATION KIT | SCALE NTS |
| DE APPR. | [illegible] | | |
| DATE | 13.10.30 | | |

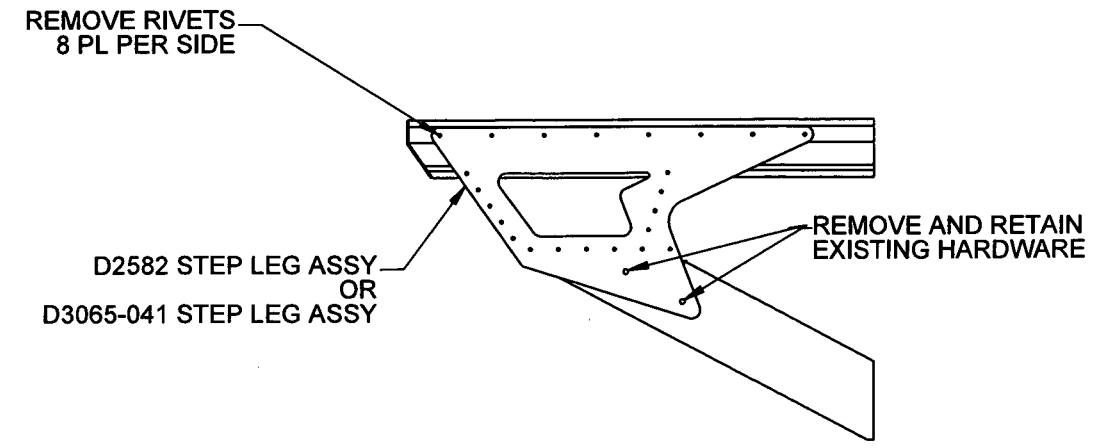


**FIGURE 1**
**(EXISTING D350-591-121/-122/-213/-214/-311/-312 CONFIGURATION REMOVAL)**

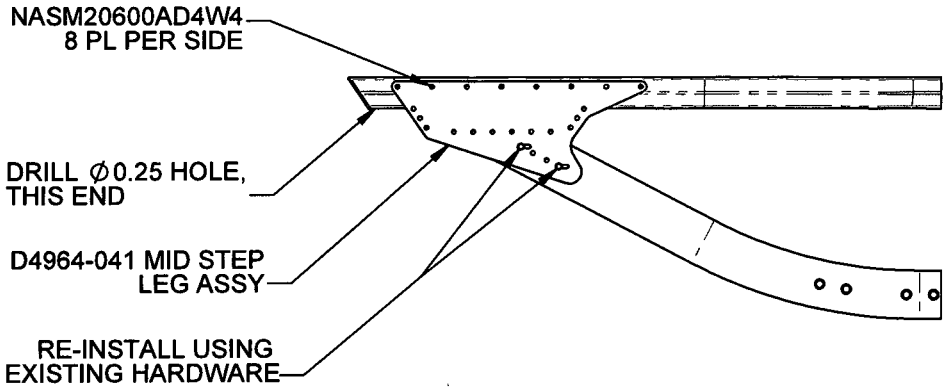


**FIGURE 2: DSI 9670-011 CONFIGURATION**
(TO MODIFY D350-591-121/-122 STEPS)

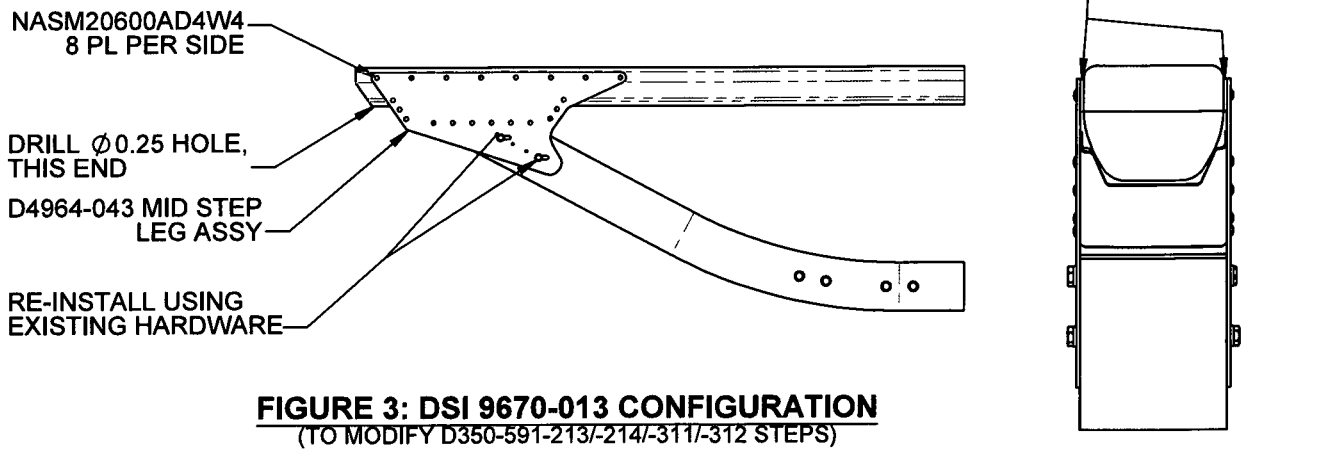


**FIGURE 3: DSI 9670-013 CONFIGURATION**
(TO MODIFY D350-591-213/-214/-311/-312 STEPS)

| | | | |
|---|---|---|---|
| DESIGN | DB | **DART AEROSPACE LTD** | |
| DRAWN | DB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | [signature] | DRAWING NO. DSI 9670 | REV. A |
| MFG. APPR. | N/A | | SHEET 3 OF 3 |
| APPROVED | [signature] | TITLE HIGH SKID MID STEP MODIFICATION KIT | SCALE NTS |
| DE APPR. | [signature] | | |
| DATE | 13.10.30 | | |